

split
Rush
Work Order ID 145412-2

145412

Page 1

Item ID: D3570-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 4/28/2016

Start Qty: ¹⁶~~6.00~~

6

Cust Item ID:

Required Date: 5/5/2016

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MCS

Date: MAY 06 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3570

Rev E

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3570

Dwg Rev: E

Prog Rev: E

GRAIN DIRECTION AS PER DWG

2-Deburr if necessary

PR 06/08/2016

20

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20

/dc 16/06/10

Work Order ID 145412

Friday, May 06, 2016 8:03:42 AM

145412

Page 2

Item ID: D3570-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 4/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(20)			DAS 38 9-89 JUN 10 2016
130 *130* Small Fab Small Fab Small Fab	Small Fab Memo 1-Form as per Dwg D3570 Using DT8945 2-Cut excess materials per Dwg D3570. 3-Drill as per Dwg D3570 Using Dt8946	0.00 0.00				16	FF		JUL 13 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(16)			DAS 38 9-89 JUL 13 2016

Work Order ID 145412

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145412

Page 3

Item ID: D3570-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 4/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 10:25. OVEN TEMPERATURE: 300° FINISH TIME: 11:55.								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

(16)

2016/02/13
BEB

16 0 10 07 21 34 989

(16)

DAS
38
9-89
JUL 21 2016

Work Order ID 145412

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145412

Page 4

Item ID: D3570-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 4/28/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging	LOCATION : GA								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

160
 JUL 22 2016
 DAS
 21
 9-89

DAS
 21
 9-89
 JUL 22 2016

DAS
 21
 9-89
 JUL 22 2016

Picklist Print

Friday, May 06, 2016 8:03:47 AM

Page 1

Work Order ID: 145412

145412

Parent Item: D3570-1

D3570-1

Parent Item Name: Bracket

Start Date: 4/28/2016

Required Date: 5/5/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-01-30 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	74.8200	0.07	0.442105			
M6061T6S 125									**	PR 06/08/2016			
6061-T6 .125 Sheet													

Location

Loc Qty

Loc Code

MAT020

74.81995

m130745

0.79995

m134067

0.355

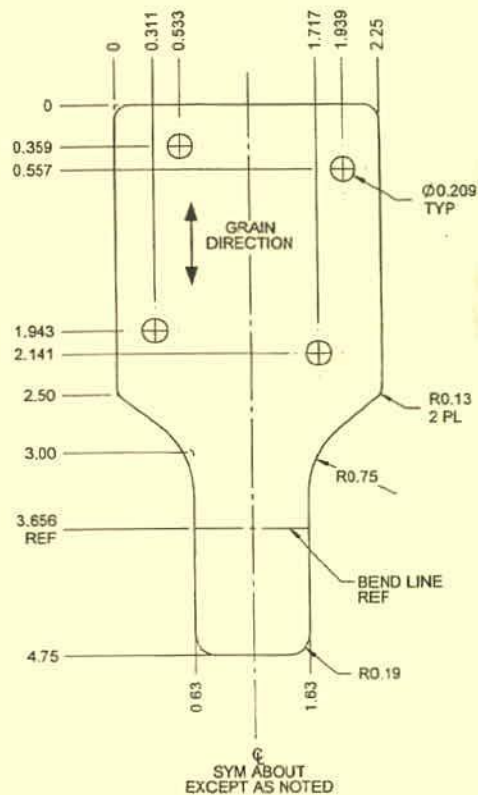
m134217

41.665

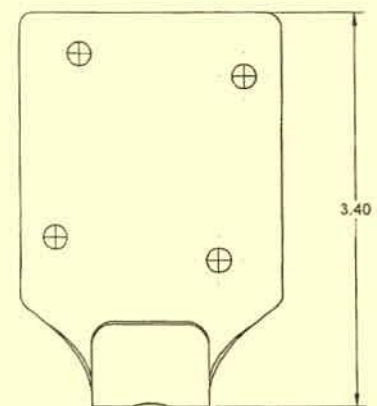
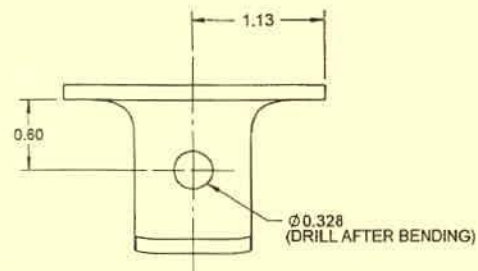
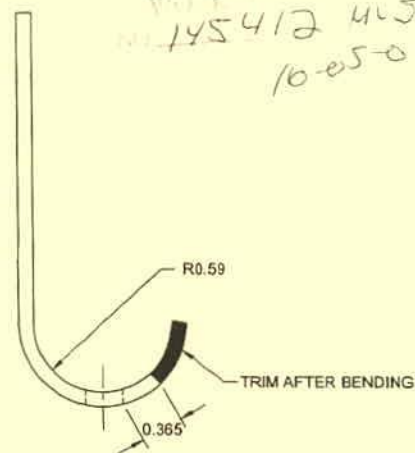
m134696

32

1.0



D3570-1F FLAT PATTERN



D3570-1 BRACKET
(MAKE FROM D3570-1F)

RELEASED
29/04/23 HJS

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3570	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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